



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D4695-1**

**Job Sheet 169410**



Part No: D4695-1

Job Qty: 4 Ea 6

Part Name: Channel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/11/17

Job Tracking No:

Due Date: 12/22/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off     |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |              |
| 90    | Start up Operation | 4 Ea  |            | 12/21/17 | 0.00      | 0.00    | Start Up Waterjet     |           |              |
| 100   | Waterjet           | 4 pcs |            | 12/21/17 | 0.00      | 0.78    | Waterjet1             |           |              |
| 110   | QC                 | 4 pcs |            | 12/21/17 | 0.00      | 0.00    | QC2 Waterjet-3        |           | DAS          |
| 120   | QC                 | 4 pcs |            | 12/21/17 | 0.00      | 0.00    | QC8-5                 |           | 38           |
| 130   | Brake NC           | 4 pcs |            | 12/21/17 | 0.00      | 0.71    | Brake NC 2            |           | SB 9-88 DAS  |
| 150   | QC                 | 4 pcs |            | 12/21/17 | 0.00      | 0.00    | QC5                   |           | 38           |
| 160   | HandFinish         | 4 pcs |            | 12/22/17 | 0.00      | 0.51    | HandFinish1           |           | BER 12/22/17 |
| 180   | QC                 | 4 pcs |            | 12/22/17 | 0.00      | 0.00    | QC7-4                 |           | 38           |
| 190   | Packaging          | 4 pcs |            | 12/22/17 | 0.00      | 0.00    | Packaging3-2          |           | 38           |
| 200   | QC21-SA            | 4 Ea  |            | 12/22/17 | 0.00      | 0.00    | QC21                  |           |              |

Part Op 100 - 1-Cut as per Dwg Dwg Rev: \_\_\_\_\_ Prog Rev: \_\_\_\_\_ 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Bend as per dwg

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

180 - QC7-Inspect Chemical Conversion Coat

190 - Identify as per dwg & Stock Location: 5446

200 - QC21- Final Inspection - Work Order Release

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | M6061T6S.040   | 6        | 356       | 0         | 0       |

### Part Specifications

Specifications could not be found.



DQA: \_\_\_\_\_ Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE / UPDATE  
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_ Work Order update only ☐

|                                  |  |                                                                            |  |
|----------------------------------|--|----------------------------------------------------------------------------|--|
| Work Order: _____                |  | AGAINST DEPARTMENT/PROCESS                                                 |  |
| Part No. _____                   |  | Water Jet <input type="checkbox"/> Engineering <input type="checkbox"/>    |  |
| NCR No. _____                    |  | Prod Eng. Coord. <input type="checkbox"/> Quality <input type="checkbox"/> |  |
| Date: _____                      |  | Other <input type="checkbox"/>                                             |  |
| Step #: _____                    |  | Approval <input type="checkbox"/>                                          |  |
| Description Work Order Deviation |  |                                                                            |  |

|                                 |  |                                                                                                                                                |  |
|---------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------------|--|
| DISPOSITION                     |  | Skid-tu <input type="checkbox"/> Machir <input type="checkbox"/> Thermoform <input type="checkbox"/> Large <input type="checkbox"/> QTY: _____ |  |
| Rework <input type="checkbox"/> |  | Suspected Unapproved <input type="checkbox"/>                                                                                                  |  |
| Scrap <input type="checkbox"/>  |  | Use-as-is <input type="checkbox"/>                                                                                                             |  |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> |  |
| No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/> |  | Temperature <input type="checkbox"/> Set-up <input type="checkbox"/> BOM <input type="checkbox"/> Brok <input type="checkbox"/> Insp <input type="checkbox"/> Con <input type="checkbox"/> Col <input type="checkbox"/> Cu' <input type="checkbox"/> Ins <input type="checkbox"/> Drin... <input type="checkbox"/>                                                                               |  |
| Environment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/>                          |  | OTHER: <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                  |  |

Mfg Date: 12/13/17  
Job No: 169410

PART NO: D4695 - 1  
Revision: Start up Operation  
Operation: Change No:



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DART AEROSPACE  
S021667  
Channel

- sitioned Wrong
- itside Dimensions
- er/Under tolerance
- art Incorrect
- art Lost/Missing
- part Moved
- Drawing
- Finish
- Misread
- Turning Sequence



